

Work Order ID 84385

shy May 17
84385

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May-11-12 7:22:34 AM

Item ID: K591-113 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Short Step Instln Kit
 Start Date: 5/11/12 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 5/17/12 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: *W* Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI9525	A

104	Pick Kit	0.00							
104									
Packaging	Memo	0.00							
Packaging									

105	QC4- 100% Inspect kits for completeness	0.00							
105									
QC	Memo	0.00							
Quality Control									

110	Identify as per dwg & Stock Location:	0.00							
110									
Packaging	Memo	0.00							
Packaging	***CHG005***								

MO 12/05/13

42/17

5, 12/17

40 12/15/17

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Item ID: K591-113 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Short Step Instln Kit
Start Date: 5/11/12 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 5/17/12 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC21- Final Inspection - Work Order Release	0.00							
120									
QC	Memo	0.00							
Quality Control									

_____ MC 12/05/12

6120517

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Required Qty: 4.00

IPP Rev:D as per revG DD
IPP Rev:E as per ECN10-586 10.06.18 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2171 Clamp		Manufactured	No			104	Each	1.0000	2	8		8/19/8	sun
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST457		1							
				68938		1							
D2274 Radius Block		Manufactured	No			104	Each	392.0000	4	16		6/8/938	16 sun
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST007		392							
				78233		2							
				81958		180							
				83258		210							
D2182B Rubber Cushion		Manufactured	No			104	f	140.9352	0.5833	2.3332			sun
(D2182B035) CUT 2 AT 3.50"				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST410		140.93517							
				63413		1.6							
				66063		41.61817							
				73932		97.717							
D2362-3 Support Bracket		Manufactured	No			104	Each	5.0000	1	4			sun
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST484		5							
				76077		5							

Picklist Print

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Work Order ID: 84385

Parent Item: K591-113

Parent Item Name: Short Step Instln Kit

Start Date: 5/11/12

Required Date: 5/17/12

Start Qty: 4.00

Required Qty: 4.00

D3595-200-300

Manufactured No

104

Each

70.5006

4

RUBBER CUSHION

Location

Loc Qty

Loc Code

MAT052

37.3336

41360

37.3336

ST415

33.167

76552

29.167

84208

4

AN3-37A

Purchased

No

104

Each

538.0000

8

Bolt

Location

Loc Qty

Loc Code

ST353

538

117619

4

119086

534

AN4-21A

Purchased

No

104

Each

45.0000

16

Bolt

Location

Loc Qty

Loc Code

ST359

45

118706

45

AN4-22A

Purchased

No

104

Each

181.0000

4

Bolt

Location

Loc Qty

Loc Code

ST359

181

116419

49

118628

82

120930

50

AN960JD10

NAS1149D0363J

Purchased

No

104

Each

0.0000

16

Washer

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Shop Packet Print

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Picklist Print

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• Work Order ID: 84385

Parent Item: K591-113

Parent Item Name: Short Step Instln Kit

Start Date: 5/11/12

Required Date: 5/17/12

Start Qty: 4.00

Required Qty: 4.00

AN960JD416

Washer

NAS1149D0463J

Purchased

No

104

Each

30.0000

6 12/20/11

24

Location

Loc Qty

Loc Code

ST351

30

116289

10

119097

20

MS21042L3

Nut

Purchased

No

104

Each

2,905.0000

2 12/20/11

8

Location

Loc Qty

Loc Code

ST300

2905

117885

32

119017

1117

119075

138

121349

638

121444

980

12/30/11

MS21042L4

Nut

Purchased

No

104

Each

5,173.0000

5 12/20/11

20

Location

Loc Qty

Loc Code

ST300

5173

119075

241

121011

1667

121444

2965

121652

300

12/20/11

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 REV. G
REF TCCA STC: SH92-6
REF FAA STC: SH967NE

PURPOSE:

TO PROVIDE AN OPTIONAL CUSHION KIT TO BE INSTALLED ON THE D350-591-111A/-113/-115/-117A/-119 *Heli-Access-Step*™ (THE D2856-400-720 ABRASION STRIP IS REPLACED WITH THE D3595-200-300 CUSHION).

CHANGE:






FOR D350-591-111A/-113/-115 @ CHG 005 (OR LATER), D350-591-117A @ CHG 003 (OR LATER) AND D350-591-119 @ CHG 004 (OR LATER), THE PARTS LIST OF INSTALLATION INSTRUCTIONS D350-591 AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 IS AMENDED AS FOLLOWS:

QTY -111A	QTY -113	QTY -115	QTY -117A	QTY -119	Part Number	Description
X					D350-591-111A	Heli-Access-Step™, Long Step - High Skid
	X				D350-591-113	Heli-Access-Step™, Short Step - High Skid
		X			D350-591-115	Heli-Access-Step™, Short Step - Low Skid
			X		D350-591-117A	Heli-Access-Step™, Pre-Flight Step
				X	D350-591-119	Heli-Access-Step™, Long Step - Low Skid
	1				D2310	STEP ASSEMBLY (HIGH-SHORT)
1					D2311	STEP ASSEMBLY (HIGH-LONG)
		1			D2354	STEP ASSEMBLY (LOW-SHORT)
				1	D2355	STEP ASSEMBLY (LOW-LONG)
4	2	2	2	2	D2171	CLAMP
4	2	2	2	2	D2182B035	CUSHION
8	4	4	4	4	D2274	RADIUS BLOCK
			1		D2362-041	SUPPORT BRACKET
2	1			1	D2362-3	SUPPORT BRACKET
		1			D2362-5	SUPPORT BRACKET
2	1	1	1	1	D3595-200-300	CUSHION (NEW)
2	2	2		2	AN3-37A	BOLT
		4			AN4-20A	BOLT (REPLACED, WAS AN4-16A)
8	4			4	AN4-21A	BOLT (REPLACED, WAS AN4-20A)
1	1	1	4	1	AN4-22A	BOLT
4	4	4		4	NAS1149D0363J	WASHER (OR AN960JD10)
10	6	2	4	6	NAS1149D0463J	WASHER (OR AN960JD416)
		4			NAS1149D0416J	WASHER (OR AN960JD416L)
2	2	2		2	MS21042L3	NUT
9	5	5	4	5	MS21042L4	NUT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 10.06.08
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE.	JPH	10.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9525	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STEP CUSHION CHANGE	NTS
DATE	10.06.08	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

REFERENCE ONLY

THE DSI-9525-XXX KITS THAT ARE AVAILABLE FROM DART TO UPGRADE THE D350-591-111A/-113/-115 KITS @ CHG 004 (OR EARLIER), THE D350-591-117A KIT @ CHG 002 (OR EARLIER) AND THE D350-591-119 KIT @ CHG 003 (OR EARLIER) ARE AS FOLLOWS:

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				DSI-9525-011	STEP CUSHION KIT (FOR D350-591-111A)
	X			DSI-9525-013	STEP CUSHION KIT (FOR D350-591-113/-119)
		X		DSI-9525-015	STEP CUSHION KIT (FOR D350-591-115)
			X	DSI-9525-017	STEP CUSHION KIT (FOR D350-591-117A)
2	1	1	1	D3595-200-300	CUSHION
		4		AN4-20A	BOLT
8	4			AN4-21A	BOLT
			4	AN4-22A	BOLT
8	4	4	4	NAS1149D0463J	WASHER (OR AN960JD416)
8	4	4	4	MS21042L4	NUT

INSTRUCTIONS:

TO INSTALL THE D3595-200-300 CUSHION:

1. REMOVE THE STEP PER ICA-D350-591 SECTION 32.2
2. REMOVE THE D2856-400-720 ABRASION STRIP PER ICA-D350-591 SECTION 32.4
3. POSITION THE D3595-200-300 CUSHION AS INDICATED ON SHEET 3 OR 4 (AS APPLICABLE) OF THIS SERVICE INSTRUCTION.
4. REINSTALL THE STEP PER ICA-D350-591 SECTION 32.1 AS APPLICABLE USING THE NEW HARDWARE PROVIDED AS SHOWN ON SHEET 3 OR 4 (AS APPLICABLE) OF THIS SERVICE INSTRUCTION.

WEIGHT AND BALANCE:






THERE IS A NEGLIGIBLE WEIGHT INCREASE WITH THIS MODIFICATION.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 10.06.08
CERT. NO.: SH92-6
ISSUE NO.: 11

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9525	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STEP CUSHION CHANGE	NTS
DATE	10.06.08	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	